

Work Order ID 77020

77020

Page 1

Thursday, November 24, 2011 3:22:31 PM

Item ID: D2858-2 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge Bracket
 Start Date: 11/24/2011 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 12/5/2011 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: P Date: 11/24 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2858	Rev C								

100 BAND SAW 0.00
 100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blanks 5.850
 " Note: 1 Blank Makes 3 Parts
20 ✓

110 HAAS CNC VERTICAL MACHINING #1 0.00
 110
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1-Machine per folio FA941
 FOLIO REV: C
 DWG REV: C
 2-Deburr any rough edges
20 ✓

120 QC2- Inspect parts off machine FAI/FAIB 0.00
 120
 QC Memo 0.00
 Quality Control
20 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	B.A	12/01/05		20	0		
--	---	------------------	-----	----------	--	----	---	--	--

140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00	M/A	12-01-05		20			
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150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 0.00							
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START TIME: 8:30 FINISH TIME: 9:00
 320012

20X M/L 12/04/10

M119480

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
						20x			
						COUNT			
170	Identify as per dwg & Stock Location: <u>19</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/1/12 120

12/1/12 120

MF
12-01-12

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Picklist Print

Thursday, November 24, 2011 3:22:36 PM

Page 1

Work Order ID: 77020

77020

Parent Item: D2858-2

D2858-2

Parent Item Name: Hinge Bracket

Start Date: 11/24/2011

Required Date: 12/5/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C00.06.22Removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X01.25 0		Purchased	No			110	f	24.1120	0.163	3.431579			

M6061T6B1 500X01 250

**

6061-T6 Bar 1.50 x 1.25

Location

Loc Qty

Loc Code

MAT004

24.112

118071

0.112

119513

24

3.6 on 11/24/24

Dart Aerospace Ltd

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DART AEROSPACE LTD		Work Order:	11020
Description: Hinge Bracket		Part Number:	D2858-2
Inspection Dwg: D2858	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.173	✓		FK-04	Vern
Ø0.400	+0.005/-0.000	.403	✓		"	"
R0.125	+/-0.010	.125	✓		rad gauge	
0.328	+/-0.010	.329	✓		FK-04	Vern
0.820	+/-0.005	.820	✓		"	"
1.476	+/-0.010	1.478	✓		"	"
0.342	+/-0.010	.344	✓		"	"
0.875	+/-0.010	.875	✓		"	"
1.56	+/-0.030	1.567	✓		"	"
0.147	+/-0.010	.149	✓		"	"
0.717	+/-0.010	.717	✓		"	"
0.697	+/-0.010	.697	✓		"	"
0.229	+/-0.010	.230	✓		"	"
R0.125	+/-0.010	.125	✓		rad gauge	
R0.063	+/-0.010	.063	✓		"	
0.063	+/-0.010	.064	✓		FK-04	Vern
0.126	+/-0.010	.124	✓		"	"
0.630	+/-0.010	.632	✓		31006	Height gauge
R0.354	+/-0.010	.353	✓		rad gauge	
0.965	+/-0.010	.968	✓		FK-04	Vern
Ø0.166	+0.005/-0.000	.166	✓		"	"

Measured by: FK	Audited by: B.A	Preliminary Approval:
Date: 12/01/04	Date: 12/01/05	Date:

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	
B	11.11.07	Dwg Rev updated	KJ	

W/O:		WORK ORDER CHANGES					
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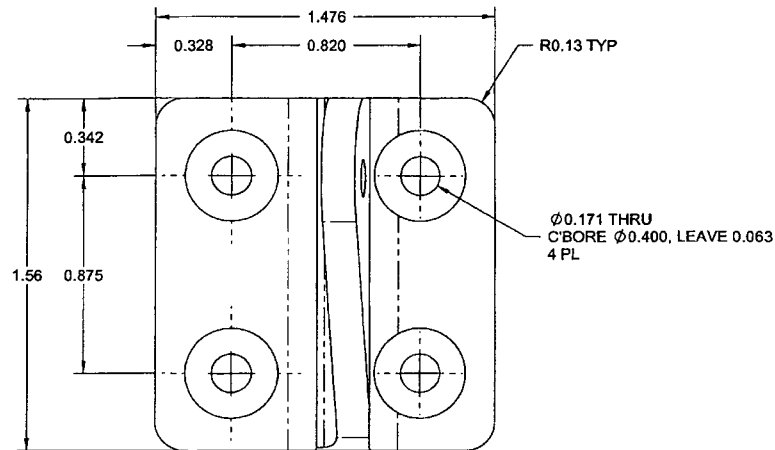
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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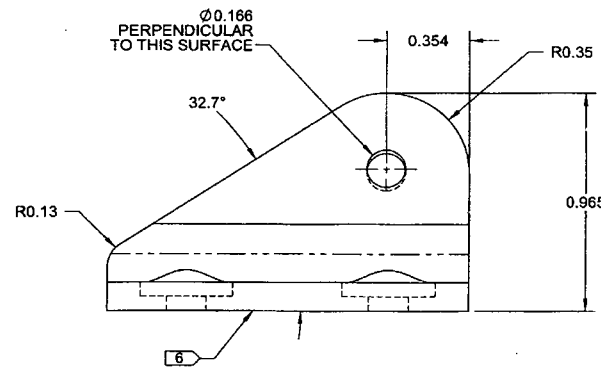
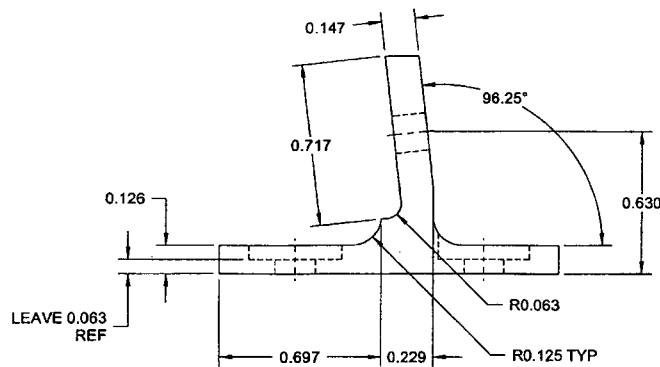
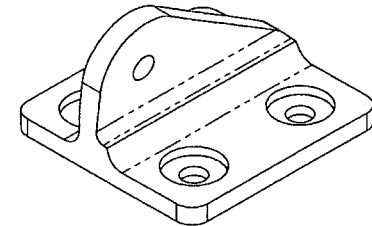
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8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77020



RELEASED
2010-11-26

D2858-1 HINGE BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM PER QQ-A-225/8 OR QQ-A-200/8 OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-1" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

C	REDRAW TO CURRENT STD, REMOVE ENGRAVED P/N, IDENT. NOW W/ MARKER (A8-1,A8-2), REF PAR 10-040	CP	10.10.12
B	0.717 WAS 0.667, 1.56 WAS 1.559	KE	99.02.28
A	NEW ISSUE	KE	98.12.14
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D2858	SHEET 1 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	HINGE BRACKET	NTS
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR TRANSMITTED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

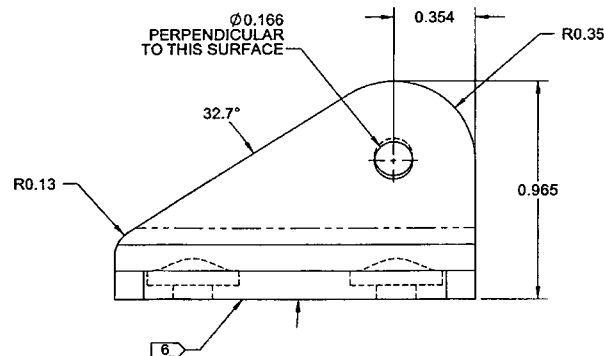
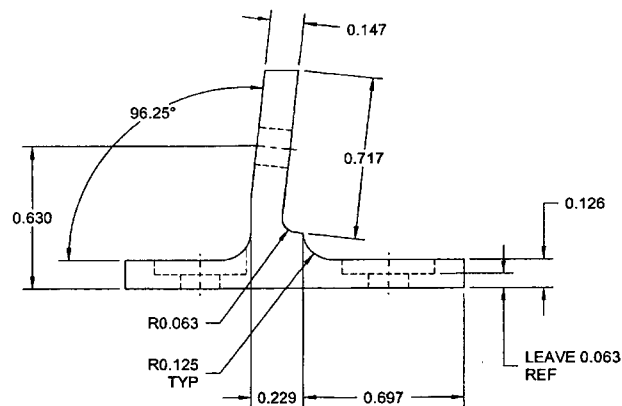
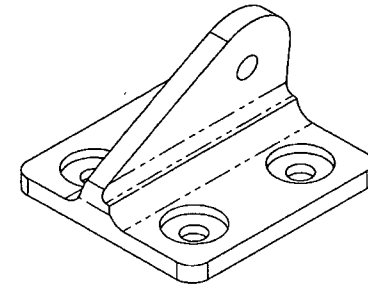
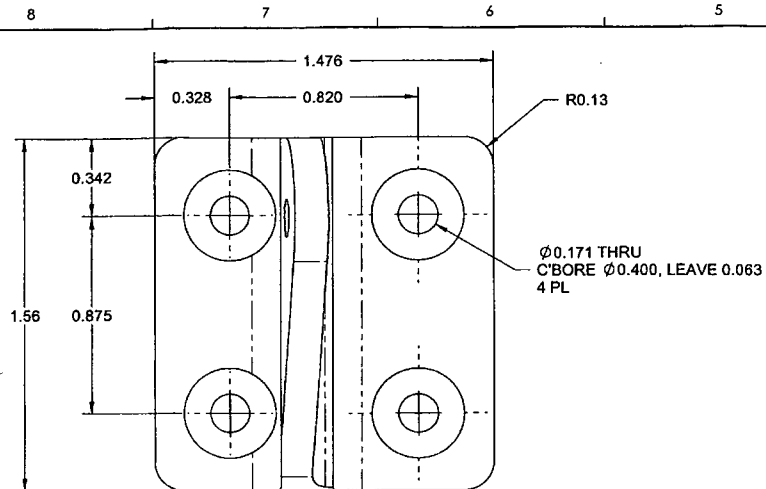
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D2858-2 HINGE BRACKET

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N "D2858-2" PER DART QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

DESIGN	KE	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D2858	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	HINGE BRACKET	NTS
DATE	10.10.12	COPYRIGHT © 1998 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR SUBMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2010-11-26

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